

Date: Friday, 7/14/2006 12:01:23 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 27923
 Estimate Number : 10008
 P.O. Number : N/A Part Number : D2591
 This Issue : 7/14/2006 S.O. No. : N/A Drawing Number : D2591 REV D
 Prsht Rev : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 26449 Material : N/A
 Due Date : 10/8/2006 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : 06.07.14
 Comment : Est Rev: Removed from 9 Digit 05-10-25 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010B0750X02500 ASTM A21 Steel .75"x2.5"



Comment: Qty.: 0.2340 f(s)/Unit Total : 9.3600 f(s)
 ASTM A36 Steel bar 2.50" x 0.75" thick(M1010-B0.750X02.500)
 Batch: 101926

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: 2.700" long

SA 06.08.26 (40)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

SA 06.08.26 (40)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 06.08.26 (40)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 06/08/28 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/28

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6151

AB 06/08/28

(40)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/08/28

(40)

Job Completion



CL 06/08/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____


DART AEROSPACE LTD		Work Order:	27923
Description: GHW Lug		Part Number:	D2591
Inspection Dwg: D2591 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

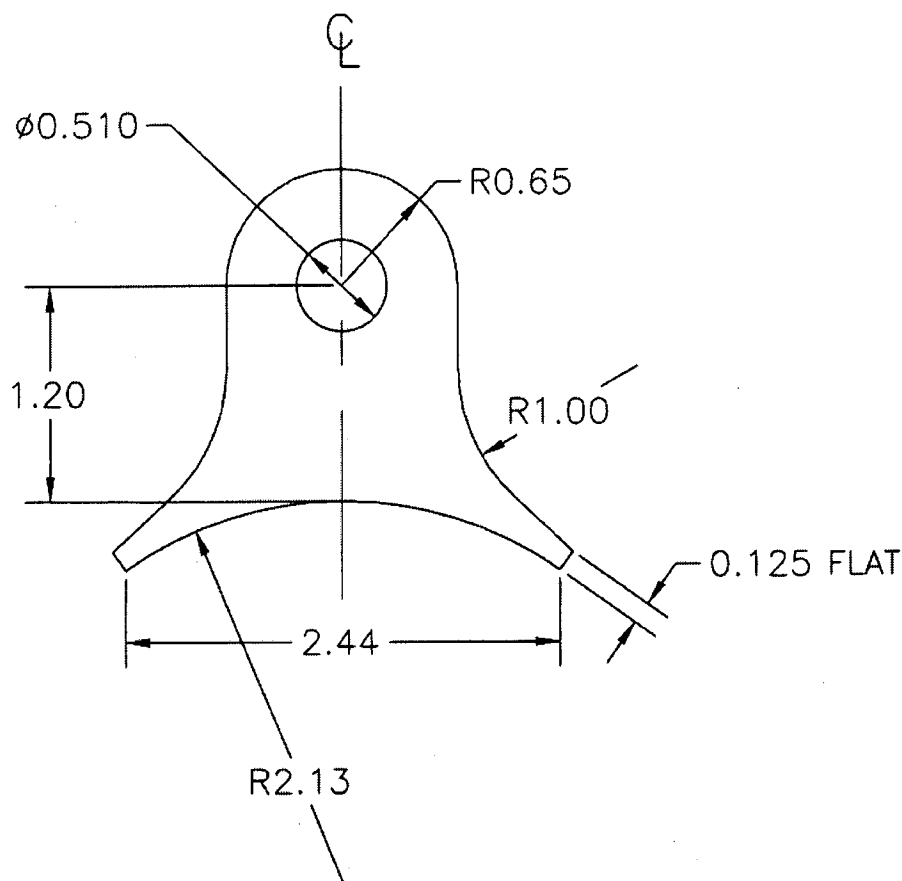
Measured by:	SD	Audited by:	J.G	Prototype Approval:	N/A
Date:	06.08.26	Date:	06/08/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue P/O D205-641-011 & DSI 9161-011	KJ/JLM	



DESIGN <i>max</i>	DRAWN BY <i>max</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BW</i>	DRAWING NO. D2591	REV. 0 SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



ALL DIMENSIONS ARE IN INCHES

NO. 27923